

Work Order ID 84891

May-29-12 1:03:48 PM

84891

Page 1

Item ID: D209-669-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/05/13 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D209-669-013	Rev B								
DSI 9450	Rev A	<u>SP</u>							
100		0.00	<u>16</u>	<u>MLJ</u>					
100	DOCUMENT CONTROL								
DC	Memo	0.00	<u>04</u>						
Document Control	Photocopy bluefile & type labels per PPP d209-669-013 CHG003								
110	Pick Kit	0.00							
110	Memo	0.00							
Packaging									
Packaging									

for MLJ 12-7-11B84924

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 84891

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84891

Page 2

Item ID: D209-669-013

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

QC

Quality Control

Memo

0.00

DAS
0.00
16

7/21/12

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD209-669-013
Location: *SD1P**12/1/12*

140

140

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/1/12

Quality Control

*ME
12-07-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 84891

84891

Parent Item: D209-669-013

D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: New IPP 08.02.13 LL, verified by:DD
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D209-669-043		Manufactured	No			110	Each	2.0000	1	1			

D209-669-043

Replacement Skidtube

Location	Loc Qty	Loc Code
Mezz	2	

D2917-1

D2917-1

Saddle LH

D2918-1

D2918-1

Saddle LH

Location	Loc Qty	Loc Code
----------	---------	----------

AN4-51A

AN4-51A

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST424	3	
-------	---	--

54467	3	
-------	---	--

ST424	3	
-------	---	--

54467	3	
-------	---	--

ST424	3	
-------	---	--

54467	3	
-------	---	--

Location	Loc Qty	Loc Code
----------	---------	----------

362	200	
-----	-----	--

121181	200	
--------	-----	--

ST361	102	
-------	-----	--

119798	30	
--------	----	--

121584	72	
--------	----	--

**

84924

**

384937

**

384467

**

80 12-7-11

8x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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D209-669-013

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2570

Manufactured No 110 Each 711.0000 24 24 **

D2570

Bushing

B85911 SP

SP

Location	Loc Qty	Loc Code
ST011	711	
72960	41	
78586	9	
79493	12	
81956	24	
81957	400	
82874	225	

MS21042L4

Purchased No 110 Each 4,095.000 24 24 **

MS21042L4

Nut

SP

SP

Location	Loc Qty	Loc Code
ST300	4095	
119075	125	
121011	713	
121444	2957	
121652	300	

AN5-36A

Purchased No 110 Each 184.0000 4 4 **

AN5-36A

Bolt

SP

SP

Location	Loc Qty	Loc Code
340	134	
121181	34	
121652	100	
ST340	50	
121708	50	

AN960JD516

NAS1149D0563J Purchased

No

110 Each 0.0000 8 8 **

AN960JD516

Washer

M119546 SP

12-7-11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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84891
D209-669-013

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased No 110 Each 1,447.000 4 4
** 80

MS21042L5
Nut



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
300	500	
121652	500	
ST300	947	
108827	8	
116105	5	
116548	43	
117611	18	
119109	865	
17651	8	

AN4-7A

Purchased No 110 Each 124.0000 16
** 16

AN4-7A
Bolt



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	124	
117514	24	
120770	100	

AN960JD416

NAS1149D0463J Purchased No 110 Each 30.0000 32
** 32

AN960JD416
Washer



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	30	
116289	10	
119097	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 84891

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

84891
D209-669-013

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2929

D2929
Spacer

Manufactured No 110 Each 86.0000 2 2 **

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST021	86	
53564	86	

D2930

D2930
Spacer

Manufactured No 110 Each 102.0000 2 2 **

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST021	102	
53563	102	

D3405-041

D3405-041
Lug Assembly

Manufactured No 110 Each 6.0000 1 1 **

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST478	6	
62227	2	
77000	2	
82031	1	
82032	1	

AN4C47A

AN4C47A
Bolt

Purchased No 110 Each 48.0000 4 4 **

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST361	48	

118451	6	
119798	2	
121009	22	
121585	18	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 84891

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

84891
D209-669-013

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

MS21043-4
Nut

Purchased No 110 Each 1,346.000 5 5

**

SP



Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1306	
119546	147	
<u>121162</u>	659	
121652	500	

D3405-043

D3405-043
Lug Assembly

Manufactured No 110 Each 2.0000 1 1

**

5X



B83897 ~~5X~~ 1X. 80

D3407-041

D3407-041
Tow Ring

Manufactured No 110 Each 27.0000 1 1

**

B85444 12-716

~~B83897~~ 1X. 80

~~12-716~~

Location	Loc Qty	Loc Code
ST463	27	
82067	6	
82068	19	
82108	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-29-12 1:03:53 PM

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Work Order ID: 84891

84891
D209-669-013

Parent Item: D209-669-013

Parent Item Name: Skidtube LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

156.0000

1

1

**

D3456-1

Washer

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	149	
80252	1	
81876	48	
83584	100	

D3417-5

Manufactured No

110

Each

78.0000

2

2

**

D3417-5

Washer

Location	Loc Qty	Loc Code
ST042	78	
78842	28	
83318	50	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84801 MUS
12/05/30

A	NEW ISSUE		AJS	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SKIDTUBE INSTALLATIONS	NTS	
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

• H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
1	1				X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
		1	1			X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1		D3405-041	LUG ASSEMBLY
51	8	8	4	4		AN4C47A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21043-4	NUT
54			1	1		D3405-043	LUG ASSEMBLY
60	1	1	1	1		D3407-041	TOW RING ASSEMBLY
61	1	1	1	1		D3456-1	WASHER
62	1	1	1	1		MS21043-4	NUT
63	2	2	2	2		D3417-5	WASHER

WAS:

50	4	4	1	1		D2736-1	GHW LUG
51	8	8	4	4		AN4-46A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21042L4	NUT (OR MS21042-4)
54			1	1		D2736-3	GHW LUG
60	1	1	1	1		D2968-041	TOW RING
61	1	1	1	1		AN970-4	WASHER
62	1	1	1	1		MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
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DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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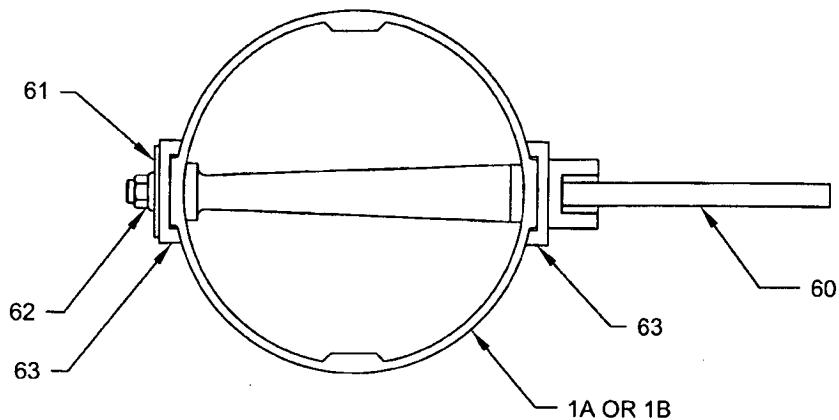
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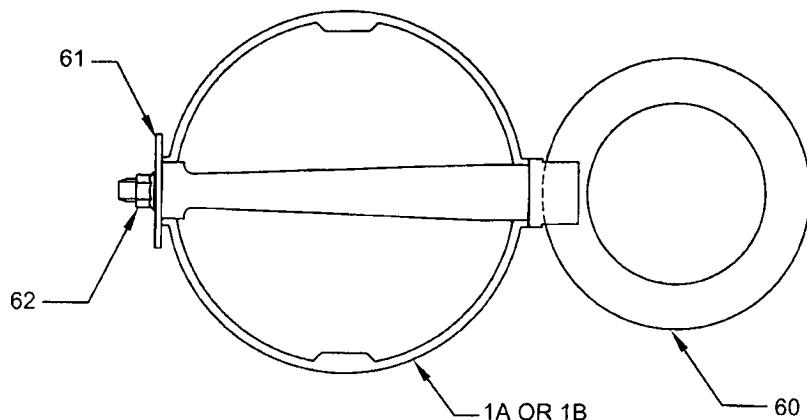
• NOTE: Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

168 hb

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	MJ	TITLE	SCALE
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